

Thursday, 9/21/2006 3:24:06 PM  
Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 28692		
Estimate Number	: 12292		
P.O. Number	: N/A	Part Number	: D26513
This Issue	: 9/21/2006 S.O. No. : N/A	Drawing Number	: D2651 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 28401	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 10/3/2006 Qty: 300 Um: Each
Checked & Approved By	: <u>[Signature] 06 09.21</u>		
Comment	: est rev. A 06/02.15 new issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 2112

Purchase P/N: 2-008 as per Dwg D2651

Supplier: Parker

Ensure Certificate of Conformity is attached

c 206109/25 (300)

2.0	MS28775008	O RING
-----	------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 300.0000 Each(s)  
O RING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

10/4/27 300

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D3446

2060928 Q5P015 (300)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5154

206109/28 (300)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *[Signature]*   Date: 06/07/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services

**Drawing Name:** PLUG

**Job Number:** 28692

**Part Number:** D26513

**Job Number:**



**Seq. #:**

**Machine Or Operation:**

**Description :**

6.0

QC21

FINAL INSPECTION/W/O RELEASE



300

**Comment:** FINAL INSPECTION/W/O RELEASE

SP 06/09/08

**Job Completion**



U 0609-28

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector





Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

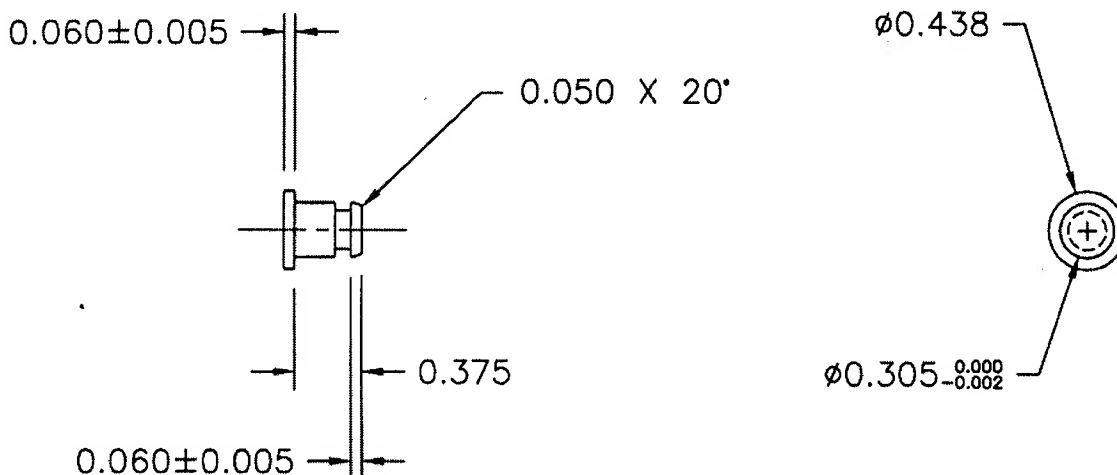
**NOTE:** Date & initial all entries



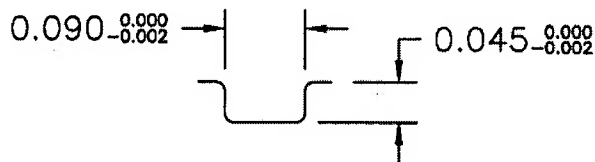
DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED  
03.12.19 *[Signature]*

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER  
3/16 ID, 5/16 OD, 1/16 WIDTH  
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28692

Copyright © 1997 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.


**Parker Hannifin Corporation**

O-Ring Division  
P.O. Box 2276  
Brownsville, TX 78522

Phone: (859) 335-3000

--- NOTICE ---  
**This is a C.B.I. Compound!**

C.B.I. is Parker's exclusive quality assurance program for Controlled Batch Identification, your assurance of reliability.

**CONFORMANCE CERTIFICATE FOR MATERIAL SHIPPED**

Parker O-Ring Division certifies that the material used in the manufacture of the parts identified below and called for on Purchase Order Number 176110 received by us from SWAN ENGINEERING & SUPPLY is traceable to C.B.I. Number 80024701 and that the material used conforms to the requirements of the specifications indicated below. The tests were performed in accordance with these specifications, and data supporting the indicated results are on file.

CUSTOMER PART NUMBER	PARKER PART NUMBER	COMPOUND	QUANTITY	CURE DATE	SHIP DATE
MS28775-008.	2-008	N0304 -75	10000	3Q04	10/07/04
TESTED AS: 2-214					
PHYSICAL PROPERTIES		REQUIREMENTS	VARIATION	PARKER FINDINGS	
SPECIFICATION MIL-P-25732C		TYPE	CLASS	TEST DT 09/04/04	
ASTMD297 SPECIFIC GRAVITY				(1.26 - 1.30)	1.2800
ASTMD2240 HARDNESS SHORE A			(68 - 80)	(70 - 80)	75
ASTMD1414 TENSILE STRENGTH, PSI			1350 MIN	(1440 - 2160)	1916
ASTMD1414 ELONGATION, %			160 MIN	(160 - 226)	225
MODULUS AT 100% ELONG.			500 MIN	(500 - 9999)	545
TR-10 50% ELONG. 10% RETURN			-49 MAX		-53.0
FLUID AGEING 70 HRS AT 275F IN MIL H-5606					
ASTMD395 COMPRESSION SET % MAX			55		33.3
TR-10			-49 MAX		-53.0
ASTMD2240 HARDNESS CHANGE			+5 -15		-12.0
VOLUME CHANGE			-20		18.8

No Mercury, Mercury compounds or Mercury bearing instruments, equipment or apparatus which might cause contamination has been used in the manufacture or subsequent processing of material covered by this order.

Purchaser use only. Reproduce only in full. Data pertains to items referenced.

The recording of false, fictitious or fraudulent statements or entries on the certificate may be punishable as a felony under federal law.

The information contained herein is submitted as the privileged and confidential property of the Parker Hannifin Corporation pursuant to 5 U.S.C. Section 552 (b)(3) and (b)(4), the Freedom of Information Act, exemption Number 3 and Number 4. This information shall not be duplicated, used or disclosed in whole or in part outside the recipient organization without express written consent of the Parker Hannifin Corporation.

O-Ring Division  
**PARKER HANNIFIN CORPORATION**

By

Ruben Ramirez  
Quality Assurance Manager